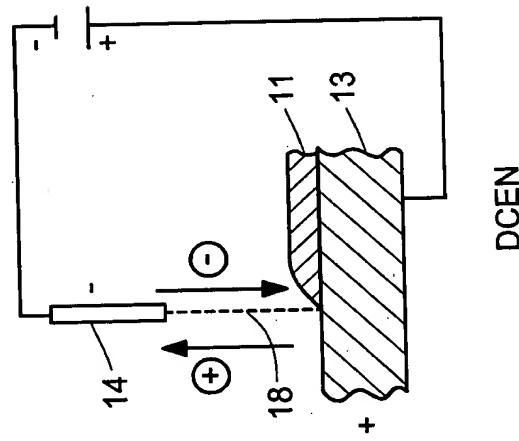
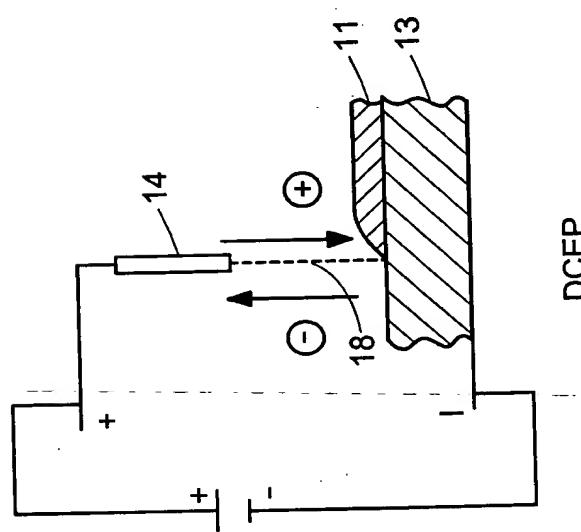


FIG. 1



DCEN

FIG. 2B



DCEP

FIG. 2A

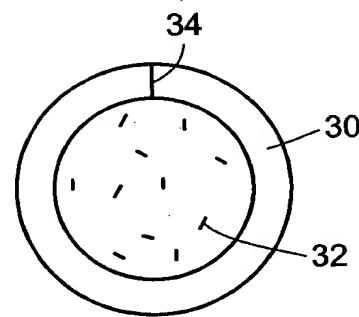


FIG. 3

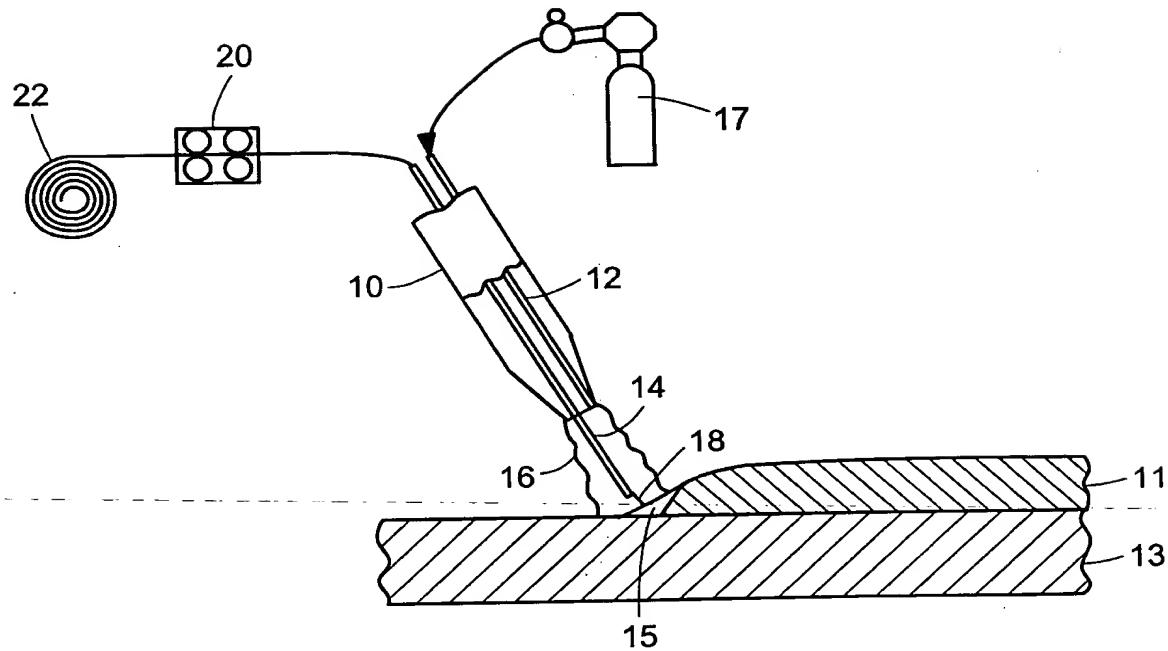


FIG. 4



Fillet size	sample Id	weld par. wfs/V	DCEP travel, cm/min	sample Id	weld par. wfs/V	DCEP travel, cm/min	INCREASE
0.125	A2	580/30	135	D2	620/27	185	37.0%
0.187	A3	620/30	120	D3	780/29	165	37.5%
0.25	A4	620/29	100	D4	780/30	135	35.0%
0.3125	A5	620/29	60	D5	780/30	75	25.0%

* note: the wire feeder was running at max 780 lpm, perhaps with more wfs this number could be higher

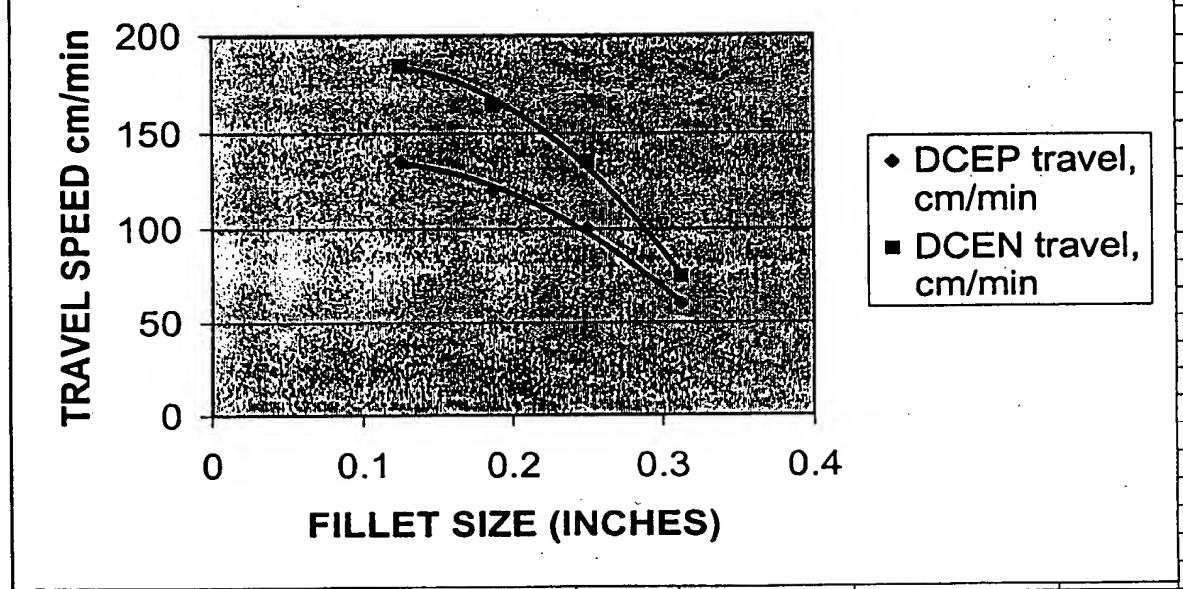


FIG. 5